

Work Order ID 82518

82518

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April-02-12 11:06:13 AM

Item ID: D2620

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube, 206 Skidtube

Start Date: 02/04/2012 Start Qty: 10.00

Required Date: 16/04/2012 Req'd Qty: 10.00

Reference:

10
10 24 DP 12-4-24

Cust Item ID:

Customer:

Approvals: Process Plan: MLJ

Date: 12/04/02 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2620

Rev B

100

Skid tubes

0.00

100

Skid tubes

Memo

0.00

Skid tubes

1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program
206.A and Folio Ft0082- Cut Fwd end of tube as per Dwg D2620

24 SAN 12-01-24

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

24 DP 12-4-25

120

Identify as per dwg & Stock Location

0.00

120

Packaging

Memo

0.00

Packaging

24 DP 12-4-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2620

Accept

N900040100Setup Start ***NS1***

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Item Name: Skidtube, 206 Skidtube

Start Date: 02/04/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 16/04/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

12/4/25 J

112-0425

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-02-12 11:06:17 AM

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Work Order ID: 82518

82518

Parent Item: D2620

D2620

Parent Item Name: Skidtube, 206 Skidtube

Start Date: 02/04/2012

Required Date: 16/04/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP D02.07.26Change Dwg to rev.B; Updated LocationRF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-1-160		Manufactured	No			100	Each	89.0000	1	10			

D2600-1-160

Extrusion Round 3" 206

14

**

SAD 12-04-24

Location

Loc Qty

Loc Code

LG

89

43969

2

59875

1

68284

4

76913

82

14

10

B 76911

10

+
D2600-1-120

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

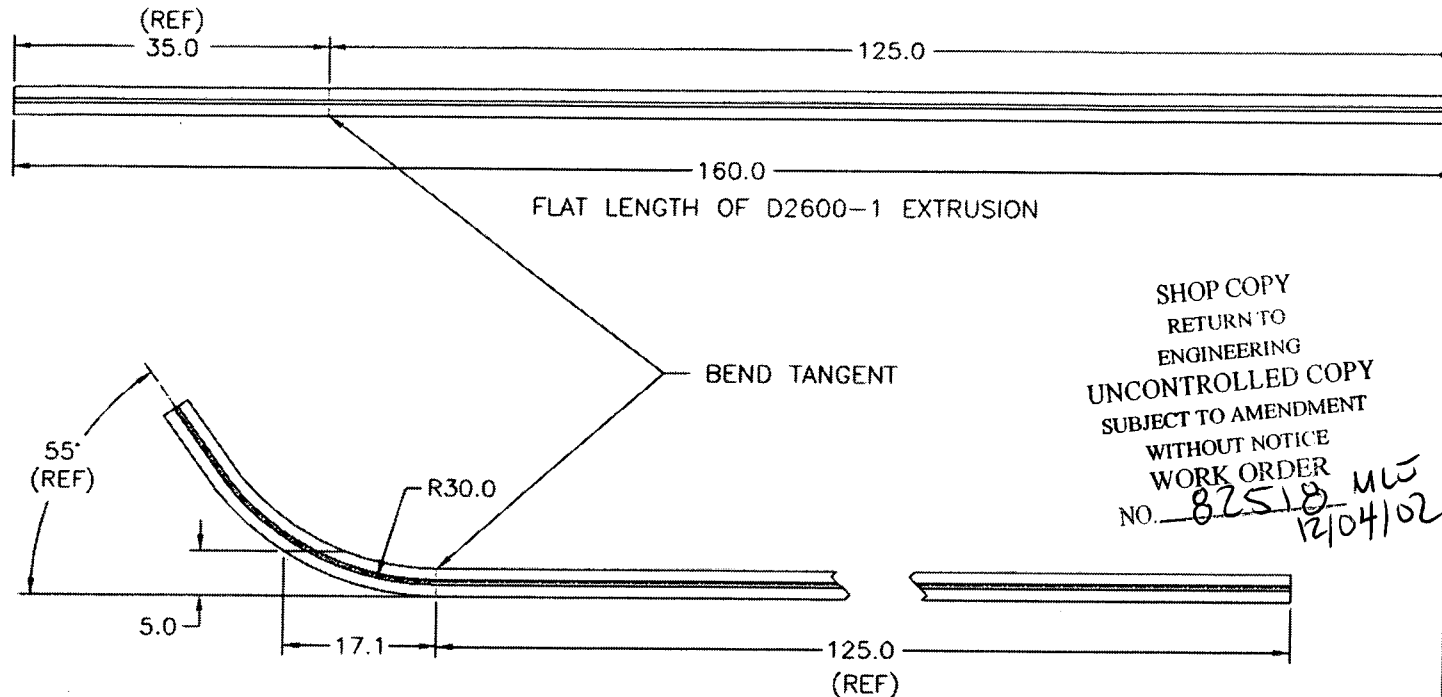
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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SPECIFICATION CONTROL DRAWING

206 SKIDTUBE BENDING



DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE. NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND. TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND. TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82518
12/04/02

RELEASED
44 04 15 DS

DART



DESIGN	DRAWN BY	TITLE	DATE	CHECKED	APPROVED	DRAWING NO.	REV. B	SHEET 1 OF 1	SCALE
	RF	DART AIRSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	99.09.10			D2620			1:20
A		NEW ISSUE	97.11.07						
B		UPDATE FOR IN-HOUSE BENDING	97.09.10						

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